Work Orde September 3, 200	r ID 51814 7										
	D3172-041 C		Accept				Set		1		
	Basket Base Assembly 09/04/2009 Start Qty: 09/11/2009 Req'd Qty:	(100) 01 110 100		Cust Item I Customer:	D:			Stop			
Approvals:	Process Plan:	Date: 09-09			ate:		Rur	n Star Stop			
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number		Plan Ac Code Q		Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr		_	-	· · · · · · · · · · · · · · · · · · ·						
D3172	Rev C										
	Large Fab		0.00								
Large Fab Large Fab	1-(Dv Re	emo Cut Qty 4 D3166-1 as per Dwg D. wg D3172[;3-Drill holes in D3172 move all markings from material ble and corner Jig & D3172T1 De	2-3 as per Dwg D3172 □4- □5-Weld as per Dwg D3172	Deburr &		O O O O O O O O O O O O O O O O O O O	9.09. ? 09	D9.			
	QC9- Inspect v	isual per QSI004- Fusion Welds	0.00			M	1 09 /20	a 114	r		
QC Quality Control	M	emo	0.00			NEL (51/0	u f 2 7			
	QC6- Inspect d	limensions to drawing	0.00 => 5) क्रीक्रीए		(.		٨			
QC Ouality Control	Me	ето	0.00	·		(-	16/	-Ψ			

	/O. WORK ORDER				······				
W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	es No DG)A:	Date: _	
		solution:							
NCR:		,	WORK ORD	ER NON-CONFORM	MANCE (N	CR)			
DATE	STED Description of NC			Corrective Action Se	ection B	Verif	ication	Approval	Approval
	STEP	Section A	Initial Action Descript Chief Eng Chief Eng		n Sig Da	n& _{Sec}	tion C	Chief Eng	QC Inspector
4									
	1								1

C

September 3, 2009 2:32:34 PM

Page 2

Item ID:

D3172-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Basket Base Assembly

Start Date:

09/04/2009

Start Oty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Draw

Number

Run

Start

Stop



Required Date: 09/11/2009

QC: ____

SPC (Y/N):

Set Up/

Date:

Plan

Code

Draw

Rev.

Accept

Oty

Reject Reject Qty

Insp. Number Stamp

130

Sequence ID/

Work Center ID

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Run Hours 0.00

* pressore wash M112266

0.00

1ST COAT: ☐ START TIME: 7.36 □FINISH TIME:

7'00 P COVEN TEMPERATURE:

Memo

140

Quality Control

QC3- Inspect Part Finish

04^09-15

Memo

51818

150

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

Packaging

0.00

W/O:			WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date:					
Resolution:		Disposition:	QA: N/C	QA: N/C Closed:								

NCR:		,	WORK ORD	ORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Annuarial						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
								1				
	f I											
							·					

	W	ork	Oi	rder	ID	513	81	4
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September 3, 2009 2:32:34 PM



Page 3

Item ID:

D3172-041

Accept

Setup Start

Stop



Revision ID:

C

Item Name: Basket Base Assembly

> Start Qty: 1.00 09/04/2009

Req'd Qty: 1.00 **Required Date:** 09/11/2009



Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Date:

SPC (Y/N):

Date:

Qty

Stop

Sequence ID/

Operation **Work Center ID** Description

QC:

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Draw Number

Draw Plan Rev. Code

Reject Accept Qty

Reject Insp. Number

Stamp

160

Quality Control

Memo

0.00

0.00

09/09/15 H

W/O:			WORK ORDER CHANGES												
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector								
Part No	:	PAR #:	Fault Cate	gory:	NO	CR: Yes	No DQ	A:	_ Date: _						
	R	esolution:	Dispositio	າ:	Q.	A: N/C CI	osed:		Date: _						
NCR:			WORK ORDI	ER NON-CONFO	DRMANC	E (NCR	1)								
DATE	CTED	Description of NC		Section B			cation	Approval	Approval						
DAIE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date		tion C	Chief Eng	QC Inspector					
							Ė								
1			i												

Picklist Print

September 3, 2009 2:32:33 PM

Work Order ID: 51814

Parent Item:

Comments:

D3172-041RevC

Parent Item Name: Basket Base Assembly

Manufactured

No



Start Date: 09/04/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	1	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	6.0000	4. 0	0		

Warehouse	Lo	c Oty	Loc Code		. (0
Location			(1-16 (P)	014 (2) (ps. 05.11
Main Warehouse				PTQ CD	
ST		6			V
31101		6		(2 f	DCP(09.09.11 X
	100	Each	9.0000	2.0000	

D2232-3RevC

Basket Hinge

<u>Warehouse</u>	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	2		
50024	2		
Main Warehouse			
WA	7		
50986	7		20004.00

	•												
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _					
	Reso	olution:	Disposition	·	QA: N/C	Closed:		Date: _					
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)							
	0755	Description of NC		Corrective Action Section		Verifi	cation	Approval Chief Eng	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C		QC Inspector				

September 3, 2009 2:32:33 PM

Work Order ID: 51814

D3172-041RevC

Parent Item Name: Basket Base Assembly

Parent Item:

Comments:

Manufactured



Start Date: 09/04/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	56.0000	2.0000			

Spacer Bushing

Warehouse	Loc	<u>Oty</u>	Loc Code			
Location						
Premier						
Mezz		46				
44274		37			(I) PD	09.09.09
44365		9				
Main Warehouse						
ST		10				
51126		10				
No	100	Each	37.0000	2.0000		
						_

D2581RevA1

Mounting Bracket

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	13		
46086	2		
48428	1		
51120	10		
Main Warehouse			
WA	24		
• 50872	24		2 60109-09-11

W/O:			WO	RK ORDER CHANGE	3				***************************************
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1								
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA :		_ Date:	
Resolution:			Disposition	l:	QA: N/C Cld	sed:		Date: _	
NCR:	-		WORK ORDE	R NON-CONFORMAN	ICE (NCR)			1
DATE	0755	Description of NC		В	Verifica	tion	Approval	Approvai	
DATE	STEP Description of NC Section A		Initial	Action Description	Sign &	Verification Section C		ADDIOVAL	
	ļ <u> </u>	Section	Chief Eng	Chief Eng	Date	Section	1 C	Chief Eng	QC Inspector
		Section A				Section	ı C		QC Inspector
		Section A				Section	n C		QC Inspector
		Section A				Section	n C		QC Inspector
		Section A				Section	n C		QC Inspector
		Section A				Section	n C		QC Inspector
		Section A				Section	i C		QC Inspector

Status

September 3, 2009 2:32:33 PM

Work Order ID: 51814

Parent Item:

Comments:

D3172-041RevC

Parent Item Name: Basket Base Assembly



Start Date: 09/04/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Date

Issued

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued
D3166-1RevA1		Manufactured	No		· · · · · · · · · · · · · · · · · · ·	100	Each	24.0000	4.0000	

Basket Hoop

Warehouse	<u>Lo</u>	c Oty	Loc Code	
Location				
Main Warehouse				
WA		24		
51248	٠.	12		
51474		12		
	100	Each	36.0000	8.0000

D 80 09.09.09/

D3174-1RevA1

Mounting Lug

Manufactured



Loc Qty Warehouse Loc Code Location Main Warehouse ST 36 24882 41632 30



D	art	Ae	ros	pace	Ltd
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
						1000		
		4 , ·						
l								

Part No:	PAR #: F	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:								
5.47-		Description of NC		Corrective Action Section B	Verification	Annessal	Ammuosal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

September 3, 2009 2:32:33 PM

Work Order ID: 51814

Parent Item:

D3172-041RevC

Parent Item Name: Basket Base Assembly

Comments:



Start Date: 09/04/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	441.6589	48.0000			
3 (E0101) (OD 1) (C 00) K DISE IN 181 (0) (C 1		# (5) # (5)							1 1881 1881			

Expanded Metal Flat SS

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	441.6589065	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	. 0.58	
111444	4.14	
111630	9.15	
111956	4.335517	
112147	83.1447895	
112311	193.6186	Lpl0909.14
No	100 f	1,117.989 42.1053

M304TS0.750W.065 Purchased

304 SQ Tube .75x.75x.065W

Loc Oty	Loc Code	
1117.98898		
117.98898		
1000		. 51.37
	1117.98898 117.98898	1117.98898 117.98898

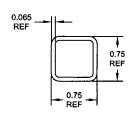
09.09.09 1

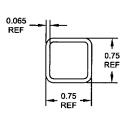
W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

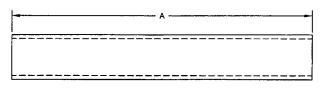
NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyes			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
						,					
	-					'					

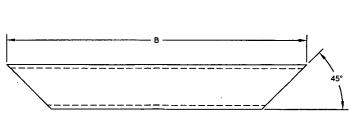
PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		Α	В	
D3172-1	2		96.00	RIB
D3172-3	2	_	25.50	RIB
D3172-5	6	33.09		RIB
D3172-7	3	26.81		RIB
D3172-9	1_	94.50	N/A	RIB
D2012-117	AZ	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

AG. 59.11 0000











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С



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NOTES:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065

2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F

3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 7) IDENTIFICATION: NONE

8) WEIGHT: N/A 9) WELD PER DART QSI 004

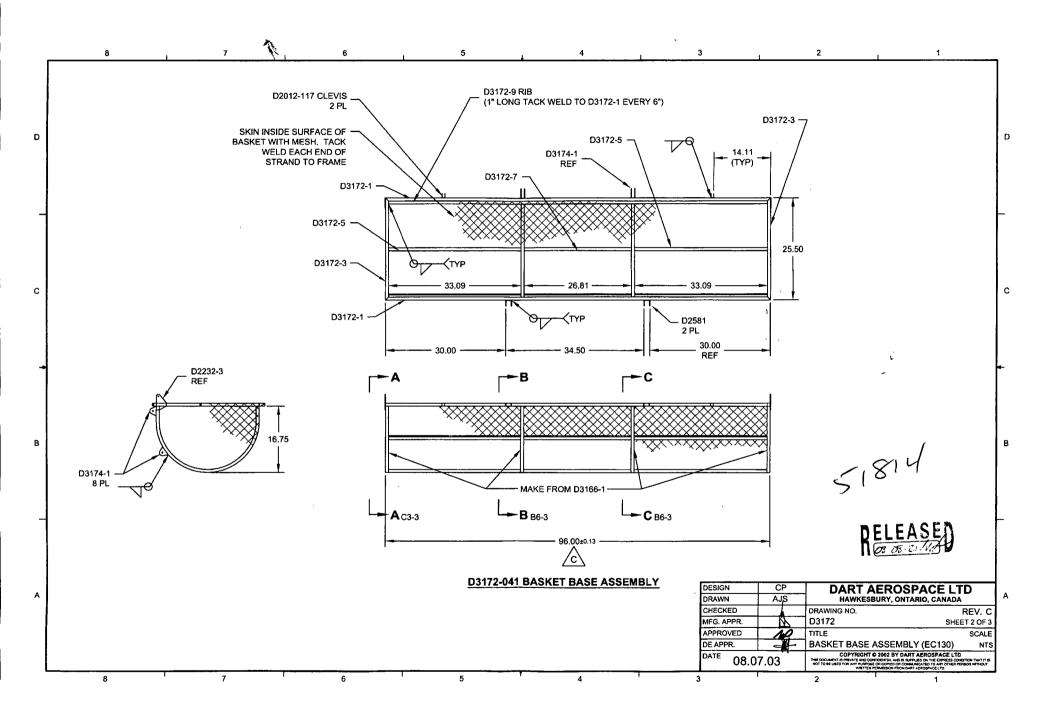
O	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
В	ADD D3172-9 & D2012-117	CP	03.01.07
Α	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE

DESIGN	CP	DART AEROSPACE LTD					
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	HAWKESBURY, ONTARIO, CANADA				
CHECKED	<u></u>	DRAWING NO.	REV. C				
MFG. APPR.	177	D3172 SHE	ET 1 OF 3				
APPROVED	10	TITLE	SCALE				
DE APPR.	-#-	BASKET BASE ASSEMBLY (EC130)	NTS				
DATE OR C	7 03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CONTROPTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS					

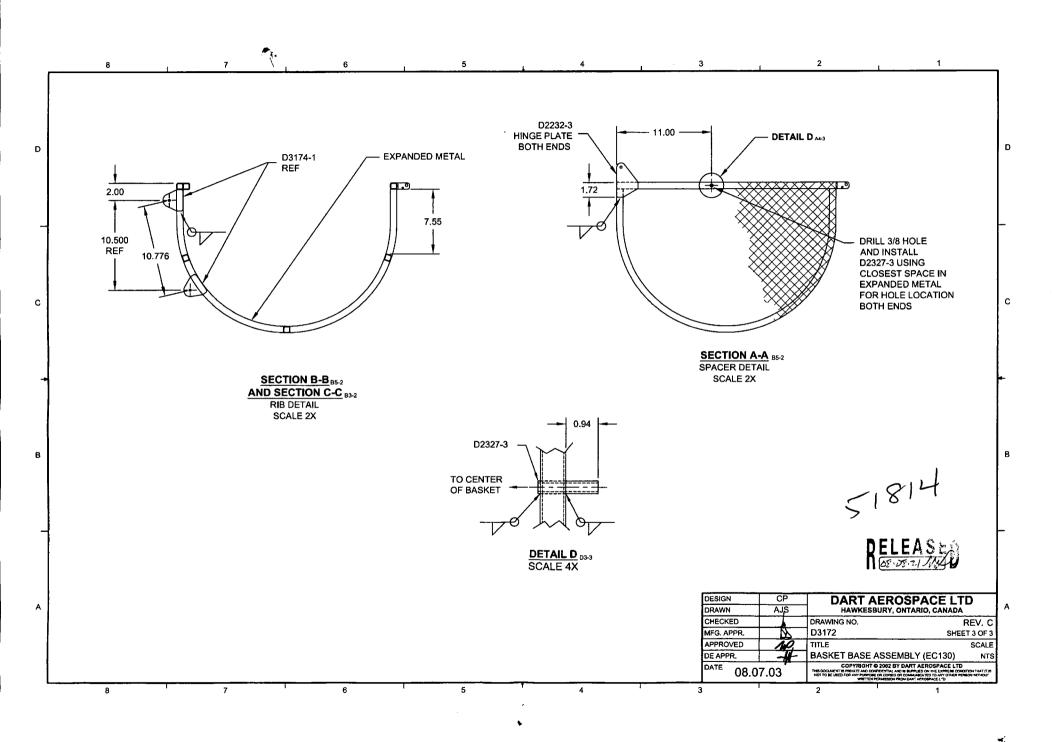
W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / 'Prod Mgr	Approval QC Inspector		
								1		
Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date: _			
	Resolution:		Disposition:	QA: N/C	Closed:		Date: _			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification		A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		

200



W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		DAD #.	Fault Car		NOD V			<u> </u>			
			Fault Category: NO Disposition: QA								
NCR:				DER NON-CONFORMAN				Date	,		
					on Section B				T		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector		
			ļ								



Dart	Aeros	pace	Ltd
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W/O:	1	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Daîle	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							A. C.			
		·				,				
Part No):	PAR #: Fault Category:	NCR: Yes	No DO	Δ.	Date:				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	3	\(\frac{1}{2} \cdot \cdo	Approval Chief Eng				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector			
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